

# Work Order ID 54344



Page 1

December 8, 2009 8:49:34 AM

Item ID:	D3769-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tube					
Start Date:	08/12/2009	Start Qty: 20.00		Cust Item ID:		
Required Date:	16/12/2009	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>RP</i>	Date:	<i>08-12-8</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3769	Rev A

100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-cut tube to lenght as per dwg D3769□2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig□3- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

*(20x)* *09/12/09*  
*Pro →*

*27 8 02/12/11*  
*(49)* *H*

*MD 09/12/17*  
*x19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3769-1 <sup>→ D412-769</sup> PAR #: \_\_\_\_\_ Fault Category: Large Fab NCR: (Yes) No DQA: / Date: 09.12.30  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05.12.31

NCR: <u>54344</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/11	<del>100</del>	Found at inspection that Qtr x1 tube has on one end the holes not concentric to each other.	<u>/</u> JOSIMZ	Scrap & Destroy no replace <del>Scrap</del> - see other since for parts that made part	<u>SA</u> 09/12/11	<u>S</u> 09/12/11	<u>/</u> JOSIMZ	<u>S</u> 09/12/11
		R.C. process.						

NOTE: Date & initial all entries

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Item ID:	D3769-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Tube				Stop	
Start Date:	08/12/2009	Start Qty: 20.00		Cust Item ID:		
Required Date:	16/12/2009	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC3- Inspect Part Finish	0.00	BL 09-12-17			(19)			
QC	Memo	0.00							
Quality Control									

140	Identify as per dwg & Stock Location: 250	0.00							
Packaging	Memo	0.00							
Packaging									

150	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/12/17 (19x) SP

09/12/18

BL 09-12-18 (19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 8, 2009 8:49:38 AM

Page 1

Work Order ID: 54344

Parent Item: D3769-1

Parent Item Name: Tube


Comments:

Start Date: 08/12/2009

Required Date: 16/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	58.3994	25.3474			
												
6061T6 RD TUBE 1.00 x .065w												

20x

6/10/12/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

58.3994082

110778

2.18

111029

56.2194082

25,3474

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

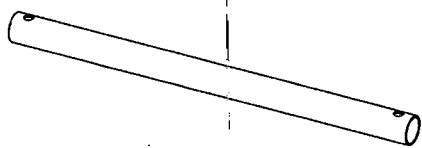
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

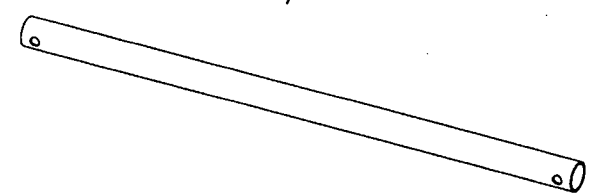
8 7 6 5 4 3 2 1



D3769-1 TUBE



D3769-3 TUBE



SHEET NO. 1  
REV. 1  
ENCLOSURE 1  
UNCONTROLLED  
SUBJECT TO  
WITH  
WORK  
NO. 54344  
R 0925

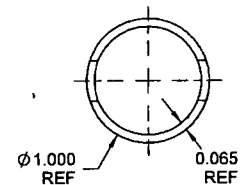
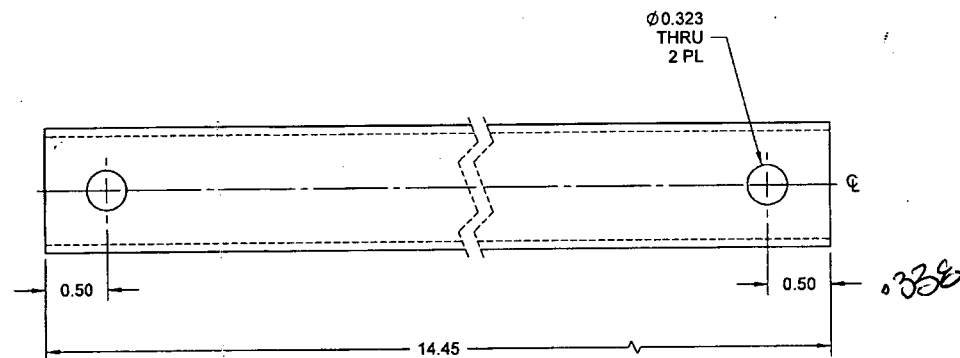
D3769-5 TUBE

RELEASED  
08-06-15-10

- NOTES:
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D3769-1, 0.27 lbs  
D3769-3, 0.28 lbs  
D3769-5, 0.37 lbs

A		NEW ISSUE		HS	08.06.04
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	HS				
CHECKED	HS	DRAWING NO. D3769		SHEET 1 OF 4	
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8 7 6 5 4 3 2 1



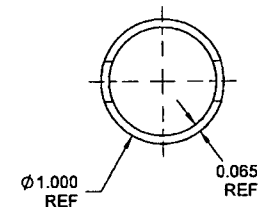
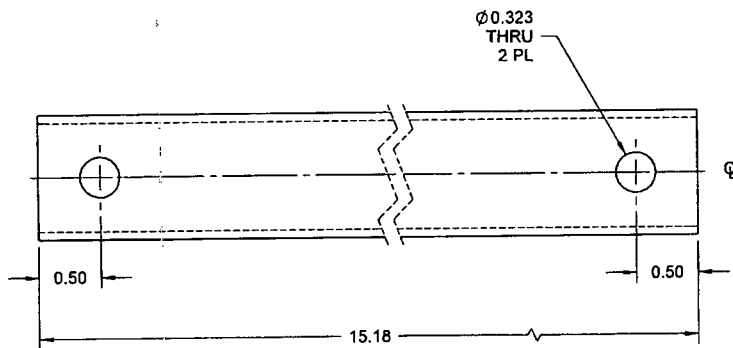
**D3769-1 TUBE**

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08-06-04

W10 54344

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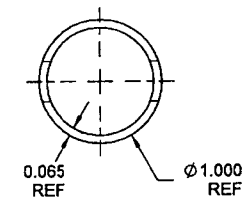
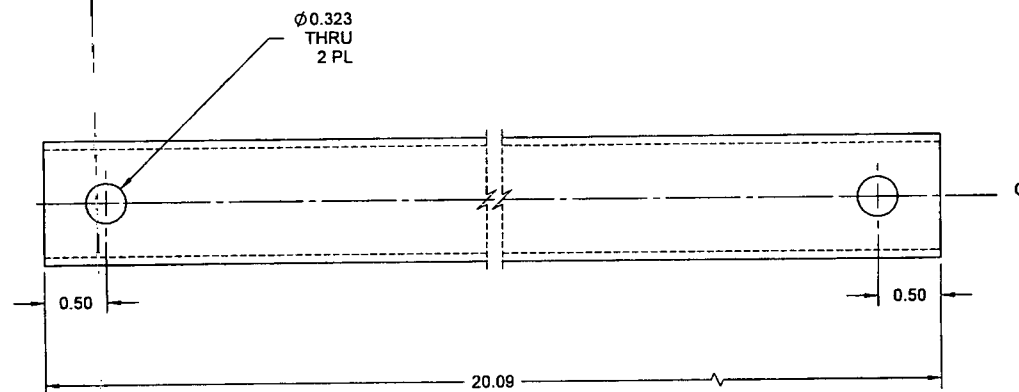


**D3769-3 TUBE**

**RELEASED**  
09-06-14/14

*w/0 54374*

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**D3769-5 TUBE**

**RELEASED**  
08-06-16 11:11

W1654344

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